

Date: Tuesday, 2/28/2006 10:48:03 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CC-DAR01 Dart Aerospace Ltd.		<b>Drawing Name</b>	: K10003	
<b>Job Number</b>	: 26006		<b>Part Number</b>	: K10003	
<b>Estimate Number</b>	: 10804		<b>Drawing Number</b>	: REWORK SADDLES	
<b>P.O. Number</b>	: N/A		<b>Project Number</b>	: N/A	
<b>This Issue</b>	: 2/28/2006 <b>S.O. No.</b> : N/A		<b>Drawing Revision</b>	: N/A	
<b>Prsht Rev.</b>	: NC		<b>Material</b>	: N/A	
<b>First Issue</b>	: 2/28/2006 <b>Type</b> : N/A		<b>Due Date</b>	: 3/7/2006 <b>Qty:</b> 1 <b>Um:</b> Each	
<b>Previous Run</b>	: 00015				
<b>Written By</b>	: <u>SPE ABOVE USER &amp; DATE</u>				
<b>Checked &amp; Approved By</b>	: <u>LL</u> <u>LL</u> <u>LL</u>				
<b>Comment</b>	: <u>NCR 021</u>				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 REWORK SADDLES - FILE EDGE OF KEYWAY PER DRWG D2571 DETAIL 5 REV.F PER DRWG D2572 DETAIL 4 REV.F PER DRWG D2573 DETAIL 5 REV.F PER DRWG D2574 DETAIL 4 REV.4 FROM D205-634-011: B24420 - K10003 B D2571, B 24125 / 72, B 24125 / 73, B 23508 / 74, B 24126 B24421 - K10003 B D2571, B 23508 / 72, B 24125 / 73, B 24126 / 74, B 24126 B24422 - K10003 B D2573, B 23509 / 71, B 24125 / 72, B 24125 / 74, B 24126 B24423 - K10003 B D2571, B 24125 / 72, B 24125 / 73, B 24126 / 74, B 24126 B24424 - K10003 B D2571, B 24125 / 73, B 24125 / 73, B 23802 / 74, B 24126 B24425 - K10003 B D2571, B 24125 / 72, B 24125 / 73, B 24126 / 74, B 24126
2.0	K10003	D205-634-011 Saddle Kit
		<b>Comment:</b> Qty.: 6.0000 Each(s)/Unit   Total : 6.0000 Each(s) D205-634-011 Saddle Kit <i>JB 06/03/01</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP
		<b>Comment:</b> INSPECT WORK TO CURRENT STEP <i>JB 06/03/01</i>
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		<b>Comment:</b> HAND FINISHING RESOURCE #1 TOUCH UP WITH ALODINE AS NECESSARY AS PER QSI 005 4.1 <i>M 06/03/01</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/04/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/28/2006 10:48:03 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: K10003

Job Number: 26006

Part Number: K10003

Job Number:



Seq. #: Machine Or Operation:

5.0 POWDER COATING



Description :

POWDER COATING



Comment: POWDER COATING

RE-POWDER COAT PER RS10004

06/04/06/30

6.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE AND IDENTIFY K10003 WITH NEW BATCH NUMBER Rev. G

REPACKAGE INTO CORRESPONDING D205-634-011 SKIDTUBES PER PPP D205-634-011 Rev. G 06/04/06/11

8.0 DC



DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

06/04/07

Job Completion



u 06/04/07

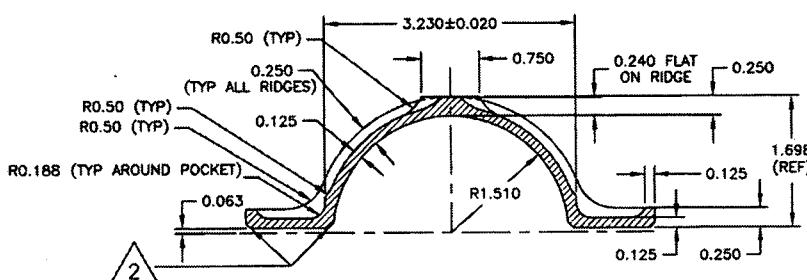
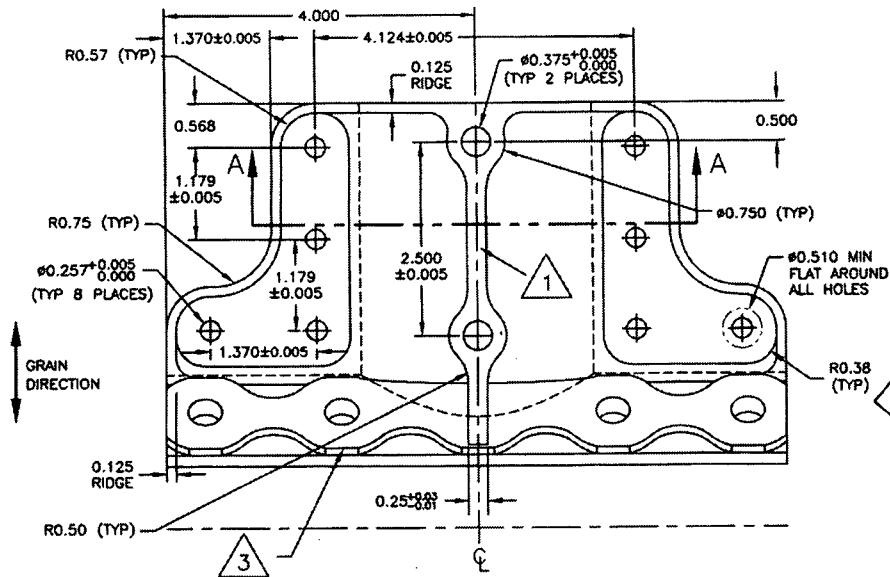
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

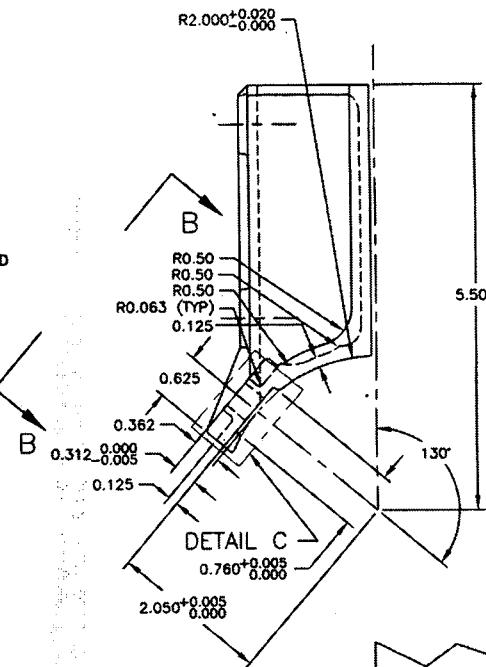
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

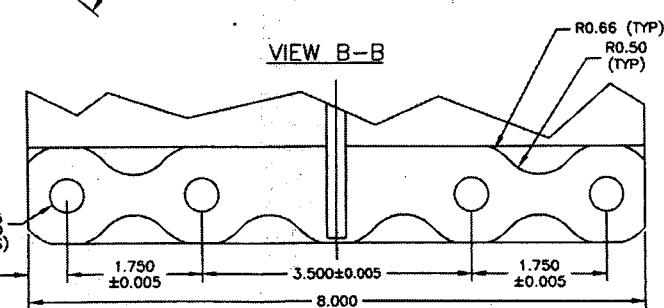


SECTION A-A

DETAIL C  
SCALE 2:1



VIEW B-B



RELEASED

05.12.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

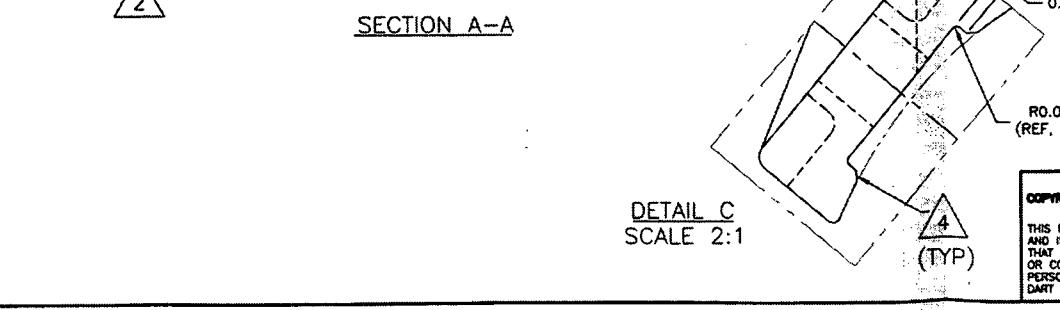
ENGRAVE PART AND BATCH NUMBER IN THIS  
AREA TO MAX DEPTH OF 0.010

CHAMFER 0.063" x 45° AROUND THIS SURFACE  
(TYPICAL 2 PLACES)

CHAMFER 0.063 x 45° ALL AROUND

CHAMFER 0.033 x 45° (SEE DETAIL C)

E



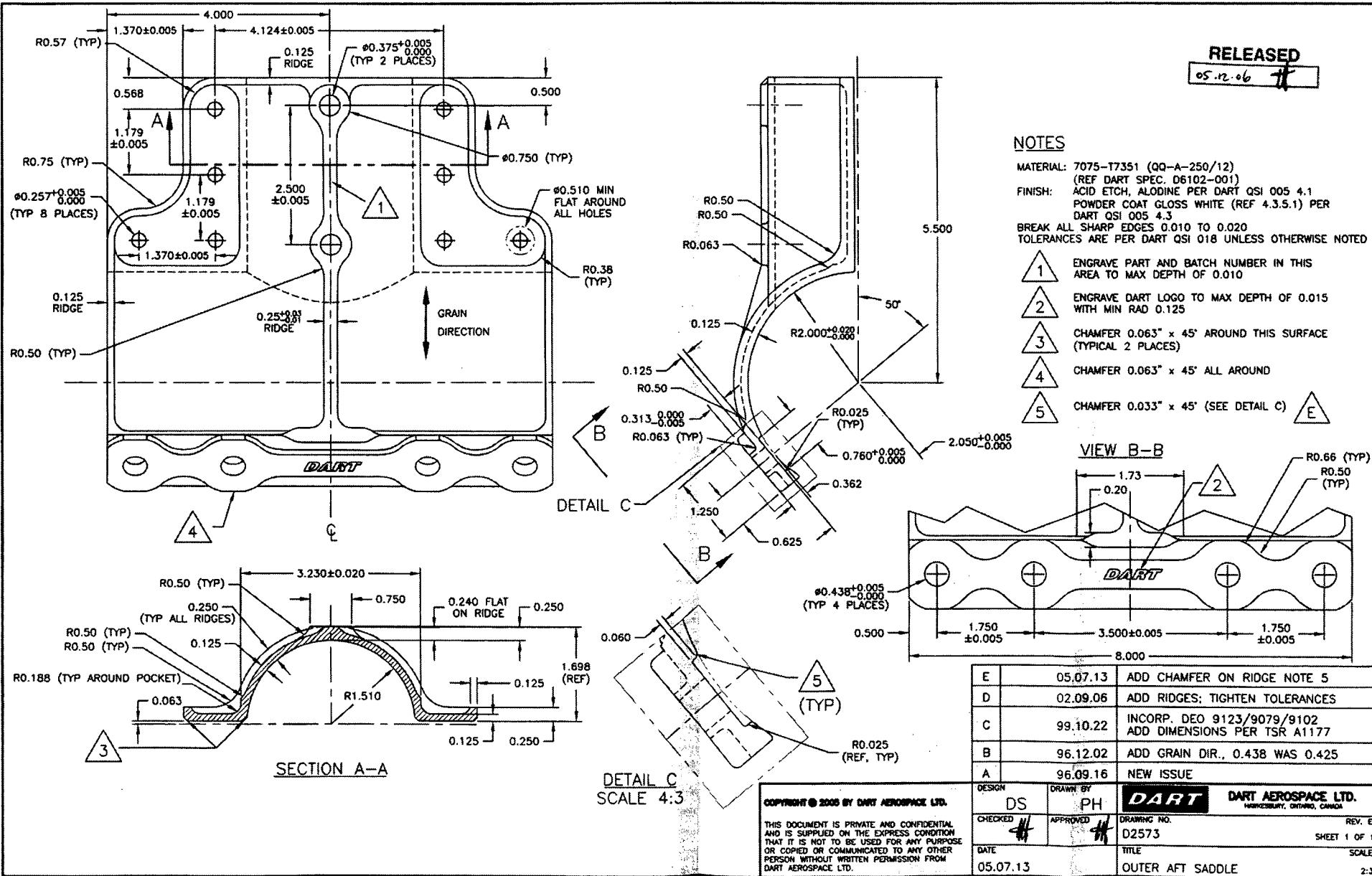
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05.07.13			TITLE INNER AFT SADDLE SCALE 2:5

REFERENCE ONLY

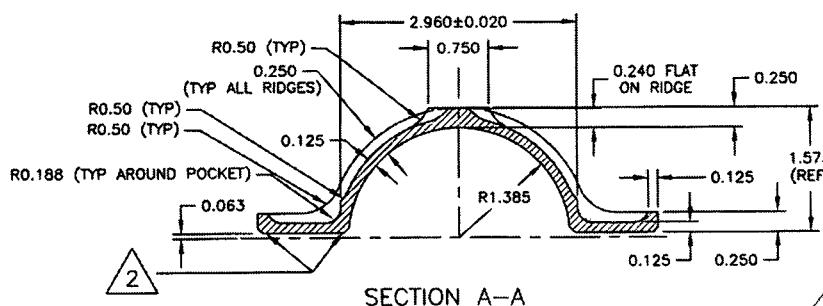
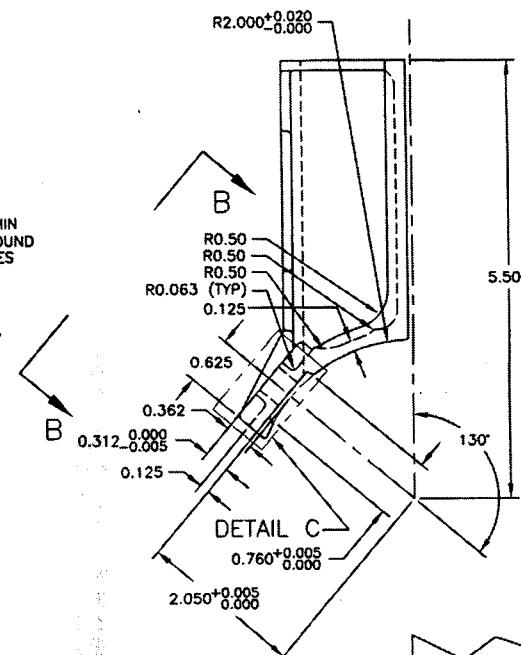
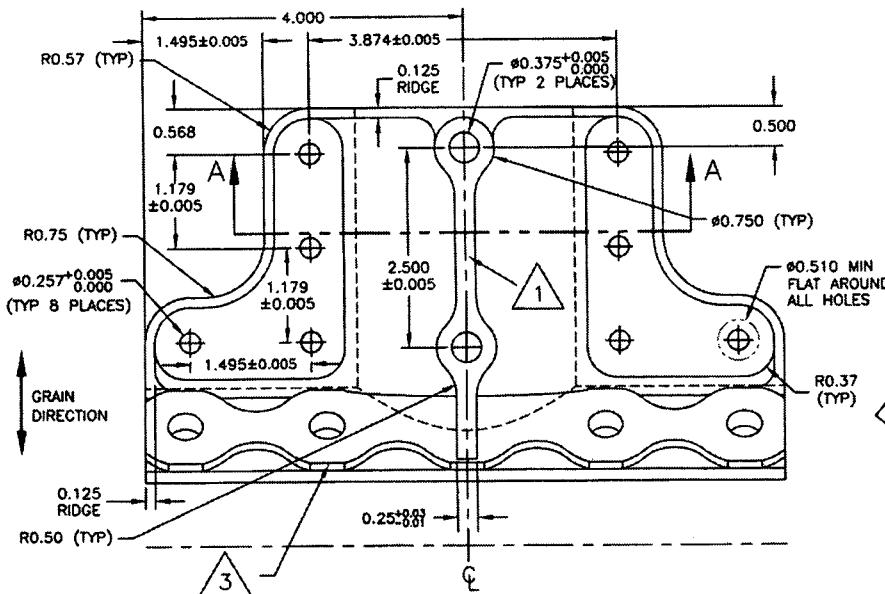
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05-12-06



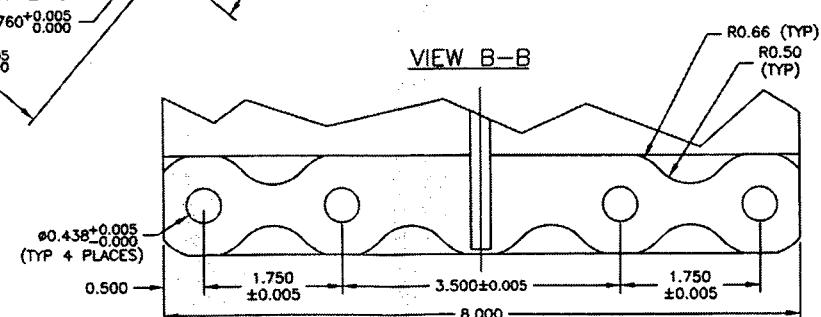
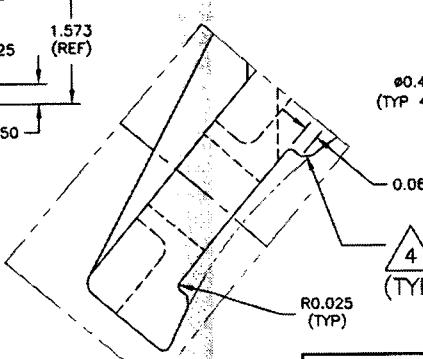
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RELEASED

05.12.06



DETAIL C  
SCALE 2:1

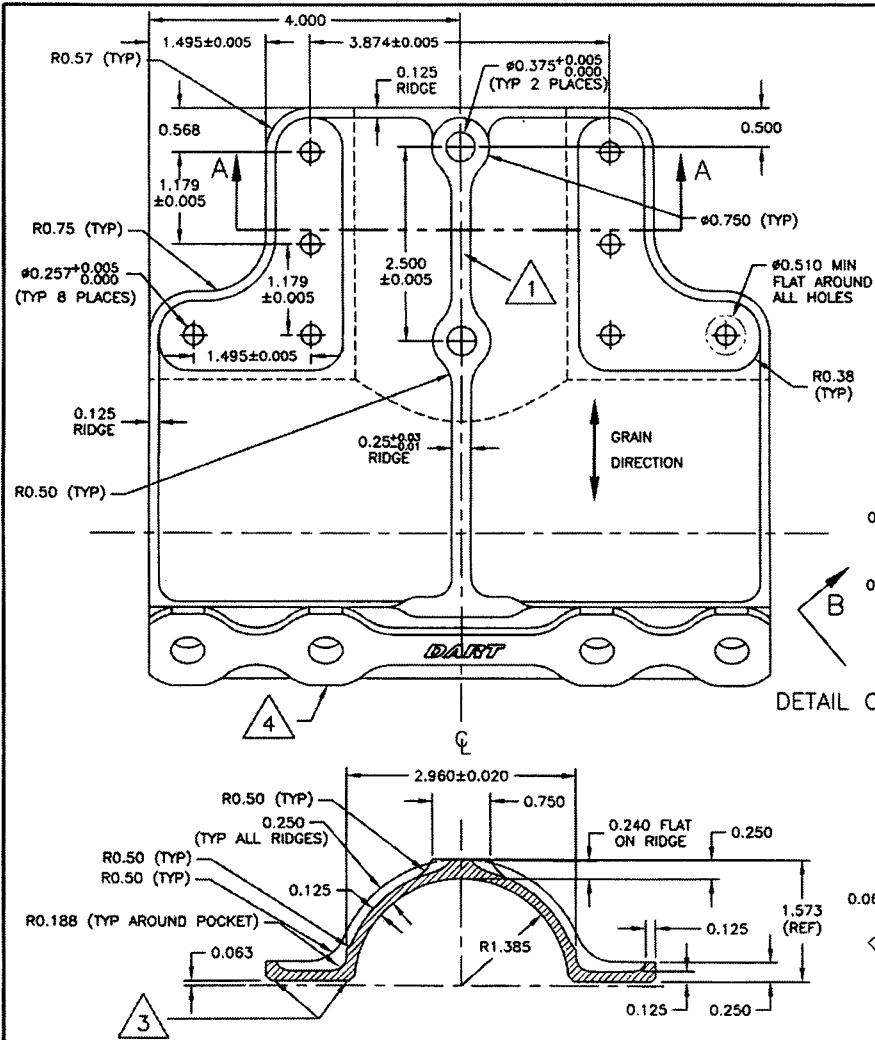


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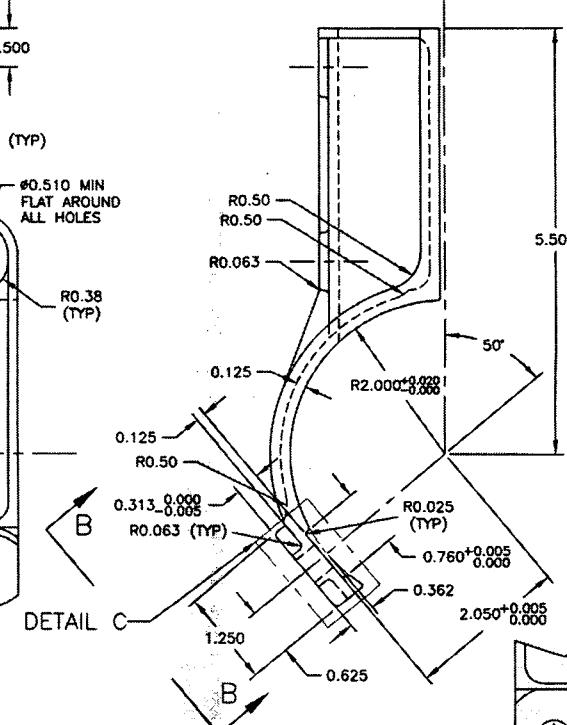
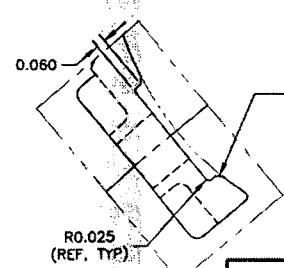
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DS	PH			REV. E
CHECKED	APPROVED		D2572	SHEET 1 OF 1
DATE				SCALE
05.07.13			INNER FWD SADDLE	2:3

REFERENCE ONLY



**SECTION A-A**

DETAIL C  
SCALE 4:3



## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

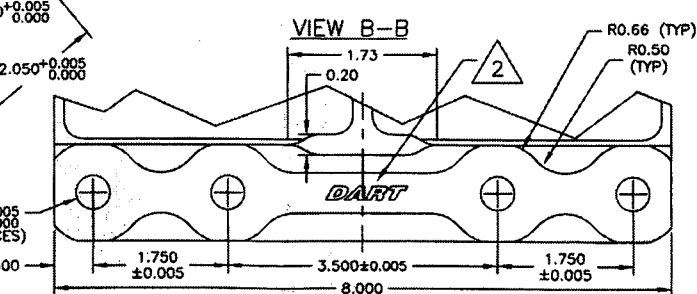
- ENGRAVE PART AND BATCH NUMBER IN THIS  
AREA TO MAX DEPTH OF 0.010

ENGRAVE DART LOGO TO MAX DEPTH OF 0.015  
WITH MIN RAD 0.125

CHAMFER 0.063" x 45° AROUND THIS SURFACE  
(TYPICAL 2 PLACES)

CHAMFER 0.063" x 45° ALL AROUND

CHAMFER 0.033" x 45° (SEE DETAIL C) ▲



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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		DATE 05.07.13	TITLE OUTER FWD SADDLE	SCALE 23	

**REFERENCE ONLY**